

Split
Work Order ID 144789-2

Monday, April 25, 2016 9:15:03 AM

144789

Ship Wednesday
Page 1

Item ID: D350-615-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: GHW Modification, Fits LH or RH
Start Date: 4/25/2016 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 4/27/2016 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: mf Date: 16-4-25 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-615-041	B								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003								
110		0.00							
110									
Small Fab	Memo	0.44							
Small Fab	Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C bolts***								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.08							
Quality Control									

2x

DAS
28
9-89

MAY 25 2016

2x

16/05/24

DAS
36
9-89

(2)

DAS
38
9-89

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144789

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.12				2	DAS 28 9-89		MAY 25 2016
140 *140* Packaging Packaging	Memo Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPR D350-615-041 Location :FG023	0.00 0.00				2X	DAS 28 9-89		MAY 25 2016
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40				ML			MAY 26 2016

ML MAY 26 2016



Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part No. _____			Rework ☐			Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____			Scrap ☐			Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
			Use-as-is ☐			Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
			Suspected Unapproved ☐			Large Fab ☐		Composite ☐		Supplier ☐			
Date :			Step #:			QTY Effective :						MRB (QSI042) Approval	
Description Work Order Deviation						Disposition							
												Completed By	
												Lead hand / Supervisor Approval Verification	
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Root Cause			FAULT CATEGORY										
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong			
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions			
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance			
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect			
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing			
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved			
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing			
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish			
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread			
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence			
Past Expiry Date ☐	☐	Manufacturing Process											
Misidentified ☐	☐	Past Due	OTHER :										

Monday, April 25, 2016 9:15:01 AM

Work Order ID: 144789

144789

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 4/25/2016

Required Date: 4/27/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Part Number	Description	Material	Quantity	Unit	Price	Value	Notes
D2282-041		Manufactured	No	110	Each	2.0000	1 4
D2282-041	T Assembly						** 16
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			B 145997
		GA	2				
		143881	2				2
D2282-043		Manufactured	No	110	Each	0.0000	1 4
D2282-043	Saddle Assembly						**
5/16-18-015C		Purchased	No	110	Each	76.0000	3 12
5/16-18-015C	SS Bolt 5/16-181.5"K						**
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		ST583	76				
		m134359	76				12
D3015-3		Manufactured	No	110	Each	122.0000	3 12
D3015-3	Locknut						**
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		FG	18				
		95758	8				
		96151	10				
		ST015	104				
		141898	104				12

APR 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 144789

144789

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 4/25/2016

Required Date: 4/27/2016

Start Qty: 4.00

Required Qty: 4.00

5/16WC

Purchased No

110

Each

157.0000

12

48

5/16WC

Washer

DAS
8
9-89

Location

Loc Qty

Loc Code

ST583

157

m134359

157

7/16-14-050C

Purchased No

110

Each

61.0000

1

4

7/16-14-050C

SS Bolt 7/16 5"K Long (92198A672)

Location

Loc Qty

Loc Code

ST584

61

m134349

61

D3015-5

Manufactured No

110

Each

47.0000

1

4

D3015-5

SS Nylock Nut 7/16

DAS
8
9-89

Location

Loc Qty

Loc Code

ST025A

47

141899

47

7/16WC

Purchased No

110

Each

18.0000

2

8

7/16WC

Washer, SS Flat 7/16

DAS
8
9-89

Location

Loc Qty

Loc Code

st572

18

120508

18

DAS
8
9-89

APR 26 2016

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WORK ORDER NON-CONFORMANCE / UPDATE



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Misidentified ☐	Past Due ☐								